



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3610
Job Sheet 168239



Part No: 646.3610

Job Qty: 12 ea

Part Name: Filler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/21/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Avialta Helicopter Maintenance Ltd (CAVIA05)

1A 27018 Sh 633 Villeneuve Airport Sturgeon County, AB, T8T 0E3 Canada ph:(780) 460-1800 fx:(780) 458-7311.

Note: DWG REV N/C IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV B:NOW ON CNC 16.08.23
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	11/20/17	11/20/17	0.00	0.00	Start Up Container		
105	Bandsaw	12 pcs	11/20/17	11/20/17	0.00	0.60	Bandsaw1		
110	CNC Vertical Machining	12 pcs	11/21/17	11/21/17	0.20	3.87	HAAS 1		
120	QC	12 pcs	11/21/17	11/21/17	0.00	0.00	QC2		
130	QC	12 pcs	11/21/17	11/21/17	0.00	0.00	QC8		
140	Outsource	12 pcs	11/21/17	11/21/17			ATG001-VC		
150	Packaging	12 pcs	11/21/17	11/21/17	0.00	0.00	Packaging2		
155	QC	12 pcs	11/21/17	11/21/17	0.00	0.00	QC5		
180	Packaging	12 pcs	11/21/17	11/21/17	0.00	0.00	Packaging3		
190	QC21-SA	12 Ea	11/21/17	11/21/17	0.00	0.00	QC21		

Part Op 105 - Cut blanks at 4.90"

Descriptions: 110 - 1-Machine per DWG AND FOLIO FB493 FOLIO REV: _____
140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.3600
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

DAS
21
9-09

JAN 19 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X01.000	5	35	0	0

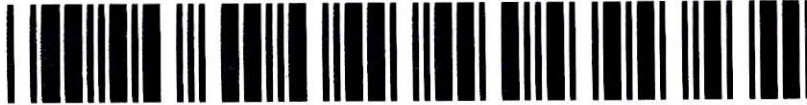
Part Specifications

Specifications could not be found.

Plex 11/14/17 6:54 AM dart.boucher.sylvie



S021581



Filler

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

PART NO: 646.3610

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/13/17

Job No: 168239

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

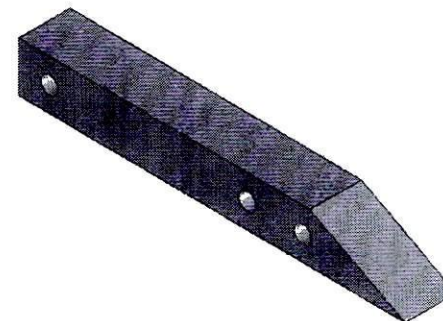
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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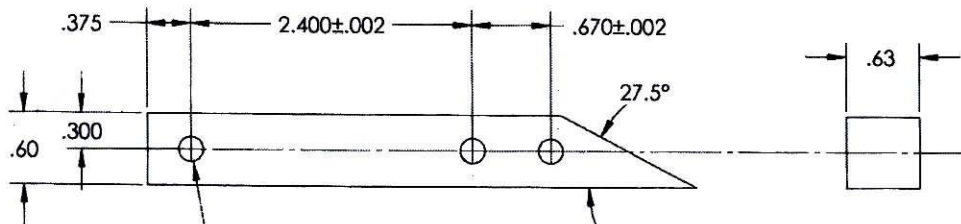
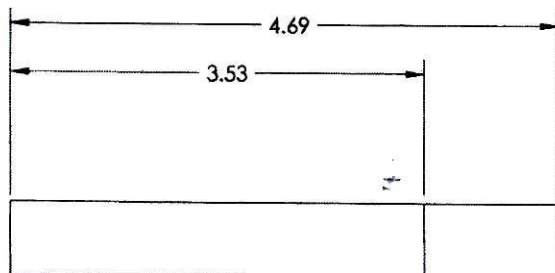
NOTES:

1. MATERIAL: ALUMINUM 6061-T6S1 PER AMS-QQ-A-250/11
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3610



SHOP COPY — Ø.209 THRU 3PL
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 168239

646.3610		FILLER		
FIND #	PART #	DESCRIPTION	MATL	SPEC.
PARTS LIST				
QTY	ORIGINAL DATE	DATE CHG	DATE CHG	DATE CHG
NEXT ASSY (S)	DRAWN BY	ENGINEER		
646.4000	S. HUFF	P. BRAYO		
	DATE APPROVAL			
	DATE CHG			
	CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED		APICAL INDUSTRIES		
DIMENSIONS ARE IN INCHES		2608 TEMPLE HEIGHTS DR.		
TOLERANCES ARE:		OCEANSIDE, CA. 92056-3512 (760) 724-5300		
2 PLACE DECIMALS ±.010		FILLER		
3 PLACE DECIMALS ±.005				
ANGLES ± 5°				
SHEET	CAGE CODE	DWG NO.	REV.	
8	07M26	646.3600	N/C	
SCALE: NONE		SHEET 1 OF 1		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038682

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Hard Anodize Black and Prime as Per Dwg 646.3800							
Line Item Note RUSH										
7	168025	646.3813	AS350 Strut Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	12/22/17	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50
							15	22-12-17	mtf	
Line Item Note RUSH										
8	168239-A	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	6 pcs	0 pcs	6 pcs	\$7.60/pcs	\$45.60
9	168239	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	12 pcs	0 pcs	12 pcs	\$7.60/pcs	\$91.20
							6x	12/1/18	mtf	
10	168280	647.0210	Rail Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	11 pcs	0 pcs	11 pcs	\$11.50/pcs	\$126.50
							12x	12/1/18	mtf	
11	168223	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	12/22/17	6 pcs	0 pcs	6 pcs	\$11.65/pcs	\$69.90
							11x	12/1/18	mtf	
Line Item Note RUSH										
12	168839	649.4813	Shim ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P-23377J Type1 Class N	Firmed	12/22/17	20 pcs	0 pcs	20 pcs	\$7.25/pcs	\$145.00
							6x	22-12-17	mtf	
Line Item Note RUSH										
13	169183	649.5212	Bracket Issue P/O to ATG : 1- Hard Anodize Black as per Dwg	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$10.00/pcs	\$50.00
							20x	22-12-17	mtf	
							5x	12/1/18	mtf	



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914370

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Fax: 615-652-5577		Ship Via	
Terms		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
11 ea	Part: 647.0210 Rail Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 22198		Rev: N/C Line: 10
5 ea	Part: 649.5212 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22201		Rev: A Line: 13
20 ea	Part: 649.4812 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22193		Rev: D Line: 5
6 ea	Part: 646.3610 Filler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22196		Rev: N/C Line: 8
12 ea	Part: 646.3610 Filler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22196		Rev: N/C
Made in Canada.			

SP18-01-11



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914370

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22197 PO: PO038682 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>05/01/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>SP18-01-11</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			